Work Order ID 74614 Page 1 Monday, October 03, 2011 4:05:32 PM Accept Item ID: D3296-1 Setup Start **Revision ID:** Stop Door Panel Item Name: **Start Date:** 10/3/2011 **Start Qty: 10.00 Cust Item ID: Required Date: 10/5/2011** Req'd Qty: 10.00 **Customer:** Reference: Start Run Process Plan: M.L. J **Approvals:** Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ **Operation** Reject Set Up/ **Tool ID** Tool # Plan Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D3296 Rev A 100 0.00 FLOW WATER JET 1B11-10-6 Waterjet 0.00 A Prog Rev: A D2-FLOW CNC Waterjet 1-Cut as per Dwg D3296 □Dwg Rev: 2524.063 Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1B11-10-6 0.00 Memo Quality Control 120 QC8- Inspect parts - second check

Memo

Quality Control

<b>-</b> a	Johago								
W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approvai Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	<b>A</b> :	Date: _	
	Re	esolution:	Disposition		QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	₹)			
DATE	STEP	Description of NC		Corrective Action Section	on B Sign		cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Date		on C	Chief Eng	QC Inspector
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Monday, October 03, 2011 4:05:32 PM

Page 2

Item ID:

D3296-1

Accept

Setup Start

Stop



Item Name: **Start Date:** 

**Revision ID:** 

Door Panel 10/3/2011

**Start Qty: 10.00** Req'd Qty: 10.00

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Required Date: 10/5/2011

Process Plan:

Date:

Date:

Tooling: SPC (Y/N): Date:

Tool # Plan

Code

Date:

Start Run

Reject

Qty

Stop

Reject

Number

Insp.

Stamp

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Set Up/ **Run Hours** 

0.00

0.00

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

16 BR 11-10-7.

Hand Finishing

HandFinish

150

140

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Accept

. ...

Qty

W/O:				WORK ORDER	CHANGES					,
DATE	STEP		PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NOD.				WORK ORDER NON-COM	FORMANCE	(NC	R)			

	\	WORK ORD	ER NON-CONFORMANC	E (NCR)				
	Description of NC		Corrective Action Section B	Varification	Approval	Approval		
STEP	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Sign &   Section C		QC Inspector	
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#### Work Order ID 74614

Page 3

Item ID:

D3296-1

Monday, October 03, 2011 4:05:32 PM

Accept



Setup Start



**Revision ID:** 

Item Name: **Start Date:** 

Door Panel

10/3/2011

**Start Qty: 10.00** 

Req'd Qty: 10.00



**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

Date:

Run

Start

Stop

Required Date: 10/5/2011

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

Operation Description

Identify as per dwg & Stock Location: ST 186

Set Up/ **Run Hours** 

Tool # Plan

Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

160

Packaging

Memo

Memo

0.00

0.00

8p. 11-10-11

Packaging

170

Quality Control

QC

QC21- Final Inspection - Work Order Release

0.00

0.00

W/O:		WORK ORDER CHANGES								
DATE	STEP		PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:		PAR #:	Fault Category:	NCR	: Yes	No <b>DQ</b>	A:	Date:	
	F	Resolution:		Disposition:	QA:	N/C (	Closed:		Date: _	

NCR:			ORK ORE	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	DATE STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
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NOTE: Date & initial all entries

#### **Picklist Print**

Monday, October 03, 2011 4:05:37 PM

Work Order ID: 74614

Parent Item:

D3296-1

Parent Item Name: Door Panel



Start Date: 10/3/2011

Required Date: 10/5/2011

Page 1

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP C□05.10.14□Added step 14□KJ/EC□

IPP Rev:D Now on Waterjet 06-11-02 JLM

Component Item ID/ Replacemen Item Name Item ID	t Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063	Purchased	No			100	sf	115.5000	0.6596	6.943158	10.8	5	
									(B)	1-10-6	2	

2024-T3 .063 sheet

Location Loc Qty Loc Code MAT022 115.5 117392 115.5



W/O:			WO	RK ORDER CHANGE	S				1.0
DATE	STEP	PRO	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	74614_
Description: Door Panel	Part Number:	D3296-1
Inspection Dwg: D3296 Rev: A		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototyp	Prototype	ticle	First Article	X
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	+/-0.030				V PSUZ	, the bank to the second secon
5.08		5085	1			
R0.06	+/-0.030	ري/ح	>		R.G.	
0.300	+/-0.010	(PPC,	3		V	
Ø0.128	+0.005/-0.000	435	>≈		V	
16.400	+/-0.005	16.400	2		T BOI	
0.300	+/-0.010	, J47	2		ν	
13.400	+/-0.005	13,400	2		7	
17.00	+/-0.030	17.00	8		7	
14.18	+/-0.030	14.18	7		7	
0.300	+/-0.010	7300	2		V	
0.063	+/-0.010	,061	>		V	
				1.77		
-11-7						
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				-		

Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	11-10-4	Date: 11/0/66	Date:	N/A

	Rev	Date	Change		Revised by	Approv <i>e</i> d
	A	04.08.24	New Issue	P/O D3296-041	KJ/JLM OK	
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	-									
W/O:			WO	RK ORDER CHANG	GES			***************************************		
DATE	STEP	PRO	OCEDURE CHAI	<b>IGE</b>	Ву	R) Verification Section C	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	<u> </u>	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _		
			Disposition: QA: N/C Closed:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)				
DATE	STEP	Description of NC Section A	Initial	Action Description	tion B	& Sect		Approval Chief Eng	Approval QC Inspector	
			Chief Eng	Chief Eng	Date					

D3296-041 DOOR ASSEMBLY

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COPIED

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

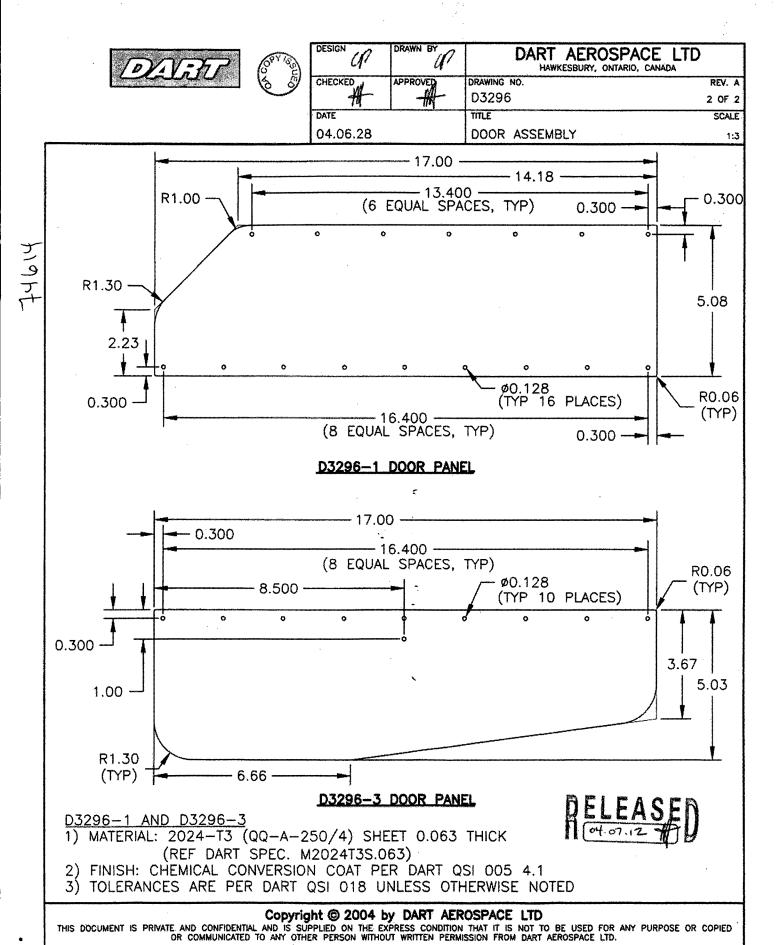
3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT

0F 2

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:				WORK ORDER	CHANGES					
DATE	STEP		PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	) <b>:</b>	<del></del>	PAR #:	Fault Category:	NCI	R: Yes	No DQ	A:	Date: _	
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NCR:		,	WORK ORD	DER NON-CONFORMANC	E (NCR)						
		Description of NC	Corrective Action Section B			Verification	A	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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Dart Aerospace	Ltd
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W/O:		WORK ORDER CHANG	GES			<b>4.</b>	
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Part No	):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	1

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:			WORK ORD	ER NON-CONFORMANC	E (NCR)	)						
DATE		Description of NC	Corrective Action Section B			Verification	A					
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